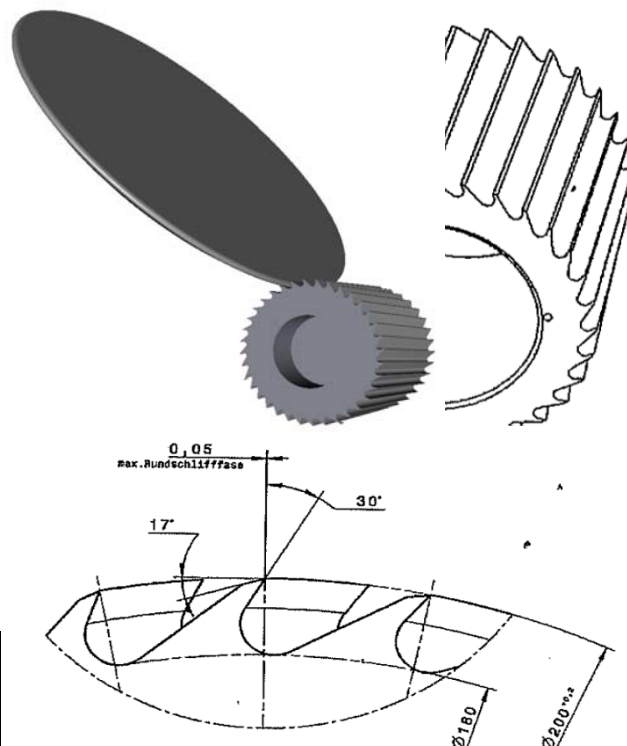





Rotor Cutter Ø200 Z36

A03-101

Flute regrinding, infeed 0.1mm (if the cutter is more damaged, more passes are needed) . O.D.2 will always be reground due to better lifetime of the tool during cutting process. Cylindrical grinding is a must.



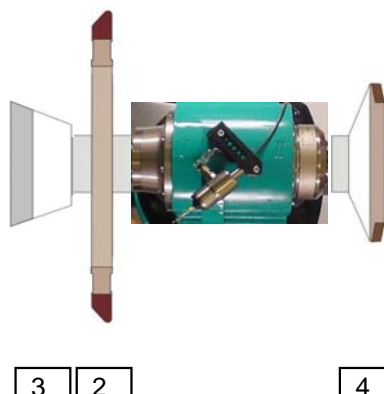
1. Cycletime for Regrinding

Workpiece: Ø 200 mm, Z 36, L 200 mm, Helix 3° Material HSS/PM390				
Operations				
Feed [mm/Min]	2000	600	500	16
Power [kW]		3	1	1
Cutting feed [m/s]		32	32	24
Used wheels				
Grinding time [s]	28	1846	1077	759
Total cycle time	61 Min 50			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø200 B126 R3.5
2	1V1 Ø200 B126 R3.5
3	11V9 Ø100 B126
4	12V2 Ø125-150 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinder: GEMINI DMR 26 kWh
Control: Fanuc 31i
Accessories:
Responsible engineer: OP. 12.11.10

Coolant: Synthetic Oil,
Software: Quinto 5

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